

IN THE CLAIMS:

1. (Currently Amended) A method for producing attached parts for a motor vehicle, including one or more of doors, dampers, mudguards, the method comprising:

providing an internal sheet and at least one external sheet with said sheets being produced separately from each other;

5 bending the external sheet inwardly by up to 90° at sides visible from outside in the edge area of an attached part;

pushing pertaining edge areas of the internal sheet against the bend of the external sheet to minimize a gap defined between edge areas of said internal sheet and said bend of said external sheet;

10 welding the internal sheet and the external sheet together by a laser beam directed into the gap between the edge areas of the internal sheet and the bend of the external sheet;

laying ~~the edges of~~ an open end of the external sheet and an open end of the internal sheet on each other in parallel to a component plane at one side at least or at all invisible sides in the edge area of the attached part lying opposite to the visible area(s), wherein said open end of the external sheet and said open end of the internal sheet extend in a direction parallel to the component plane; and

15 laser-welding in an overlap joint of the open end of the external sheet and the open end of the internal sheet or laser-welded or laser-soldered in a fillet of the overlapping parallel edges of said open end of the external sheet and said open end of said internal sheet.

2. (Previously Presented) A method according to claim 1, wherein a visible edge area of said external sheet is inwardly bent at a sill side and/or lock side of a door for motor vehicles.

3. (Previously Presented) A method according to claim 1, wherein the invisible edge areas of a hinge side and/or of a window side of the door external sheet are connected with the edge areas of the door internal sheet in the overlap joint by laser welding or in the fillet of the overlapping edge areas by laser welding or laser soldering.

4. (Canceled)

5. (Previously Presented) A method according to claim 1, wherein in the visible area where the external sheet is inwardly bent, the internal sheet, too, is wholly or partly bent inwardly or outwardly in an edge area.

6. (Previously Presented) A method according to Claim 5, wherein the bend of the external sheet forms an acute angle to the bend of the internal sheet.

7. (Previously Presented) A method according to claim 1, wherein the edge areas of the internal sheet are inwardly or outwardly bent by up to 180°.

8. (Currently Amended) A method according to claim 1, wherein the edge area of the internal sheet is arranged in parallel to the external sheet and ~~a front side of~~ the edge of the internal sheet is so bevelled that ~~said front side of~~ said edge of said internal sheet forms an acute angle to the bend of the external sheet.

9. (Canceled)

10. (Currently Amended) A method for producing a motor vehicle part to be attached to a motor vehicle body, with the attached part having a visible edge area visible by a user of the motor vehicle and a hidden or not visible edge area that cannot be viewed by a user of the motor vehicle, the method comprising the steps of:

5           forming an internal sheet;

          forming an external sheet produced separately from the internal sheet;

          forming the visible edge area by bending the external sheet inwardly at a side by up to ninety degrees to form a bend and a bent portion;[[,]]

moving said internal sheet in a direction of said bent portion such that pushing an edge  
10   area of the internal sheet is pushed against the bent portion ~~in toward the bend of the external sheet~~ to minimize a gap between the bent portion and the edge area of the internal sheet;  
          [[and]]

          welding the internal sheet and the external sheet together by a laser beam directed into the gap between the edge area of the internal sheet and the bent portion adjacent to the bend

15 of the external sheet after said internal sheet is moved in a direction of said bent portion,  
wherein said internal sheet and said external sheet define a component plane; [[and]]

forming a hidden or not visible edge area by laying ~~an edge~~ a flange end portion of the  
external sheet and ~~an edge~~ a flange end portion of the internal sheet on each other ~~in parallel~~  
~~to a component plane~~ to form overlapping flange end portions, wherein said overlapping flange  
20 end portions extend in a direction parallel to said component plane; and

laser-welding the overlapping flange portions together after said internal sheet and said  
external sheet are welded between the edge area and the bent portion to form an overlap joint  
or laser-welding or laser-soldering in a fillet at overlapping flange portions to form an overlap  
joint, wherein at least a portion of said [[edge]] flange end portion of said internal sheet moves  
25 along at least a portion of said [[edge]] flange end portion of said external sheet when said edge  
area of said internal sheet is pushed against said bent portion of said external sheet.

11. (Previously Presented) A method according to claim 10, wherein the part is a  
motor vehicle door and the visible edge area of the external sheet is inwardly bent at a sill side  
and/or lock side of the door.

12. (Previously Presented) A method according to claim 11, wherein the not visible  
edge area is at a hinge side and/or a window side of the door external sheet.

13. (Canceled)

14. (Previously Presented) A method according to claim 10, wherein the bend of the external sheet forms the bent portion at an acute angle to the internal sheet.

15. (Previously Presented) A method according to claim 10, wherein the edge areas of the internal sheet are inwardly or outwardly bent by up to 180°.

16. (Previously Presented) A method according to claim 10, wherein the edge area of the internal sheet is provided by bending an end in a direction away from the external sheet.

17. (Previously Presented) A method according to claim 10, wherein the edge area of the internal sheet is provided by bending an end in a direction toward the external sheet.

18. (Previously Presented) A method according to claim 10, wherein the edge area of the internal sheet is the end face of the internal sheet directed toward an inner surface of the bent portion of the external sheet.

19. (Currently Amended) A motor vehicle part to be attached to a motor vehicle body, comprising:

an external sheet comprising a visible edge area visible by a user of the motor vehicle, wherein a side of said visible edge area of said external sheet is bent by an angle up to ninety degrees to form a bend and a bent portion; and

an internal sheet comprising a hidden or not visible edge area that cannot be viewed by a user of the motor vehicle, said internal sheet and said external sheet defining a component plane, said internal sheet being produced separately from said external sheet, wherein said internal sheet is movable along said external sheet such that an edge area of said internal sheet is pushed against the bent portion ~~toward the bend~~ of the external sheet to minimize a gap between the bent portion and the edge area of the internal sheet, the internal sheet and the external sheet being welded together by a laser beam directed into the gap between the edge area of the internal sheet and the bent portion adjacent to the bend of the external sheet with said edge area of said internal sheet pushed against the bent portion, wherein the hidden or not visible edge area is an open ~~[[edge]]~~ flange end portion of the external sheet in contact with an open ~~[[edge]]~~ flange end portion of the internal sheet, said open ~~[[edge]]~~ flange end portion of said external sheet and said open ~~[[edge]]~~ flange end portion of said internal sheet ~~[[being]]~~ extending in a direction parallel to ~~[[a]]~~ said component plane to form overlapping flange end portions, wherein the overlapping flange end portions are laser-welded together to form an overlap joint or laser-welded or laser-soldered fillet at the overlapping flange portions to form an overlap joint, wherein said overlap joint is formed after said edge area of the internal sheet is welded to said bent portion of said external sheet.

20. (Previously Presented) A motor vehicle part according to claim 19, wherein the part is a motor vehicle door and the visible edge area of the external sheet is inwardly bent at a sill side and/or lock side of the door and the not visible edge area is at a hinge side and/or a

window side of the door external sheet.

21. (Previously Presented) A motor vehicle part according to claim 19, wherein the edge area of the internal sheet is provided by bending an end in a direction away from the external sheet or in a direction toward the external sheet.

22. (Currently Amended) A method according to claim 1, wherein said internal sheet is slidable against ~~[[and]]~~ said external sheet in said component plane ~~are movable with respect to one another prior to welding said gap.~~

23. (Currently Amended) A motor vehicle part according to claim 19, wherein said ~~[[edge]]~~ flange end portion of said internal sheet and said ~~[[edge]]~~ flange end portion of said external sheet are movable with respect to one another with said gap in an unwelded state.